

■ Date:

Wednesday, 28/01/2009 4:59:39 PM

User:

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

S.O. No. :

: 45316 : 10313

P.O. Number

This Issue : 28/01/2009

: NC Prsht Rev.

First Issue : //

: 45244 **Previous Run**

Written By Checked & Approved By

Comment

: Est: E 02.09.18

Type

Re-format; Incorporated D2648-1 Est Rev:F

Now on Waterjet 06-08-14

: SMALL /MED FAB

JLM

Additional Product

Job Number:

Seq. #:

1.0

2.0

Machine Or Operation:

M1010S16GA

Comment: Qty.: -0.0768 sf(s)/Unit Total:

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 16570 (

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:_

Prog Rev:___

2-Deburr if necessary

3.0 QC2

B 9-3-4 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

Comment: SECOND CHECK

5.0 SMALL FAB 1

Comment: SMALL & MEDIUM FAR RESOURCE

Deburr if necessary

Drawing Name : WEARPAD

Part Number Drawing Number

KJ/RF

Description:

1010/1025 sheet 16GA

: D26483 : D2648 REV D

Project Number

: N/A : D **Drawing Revision**

Material

Due Date : 10/02/2009 Qty:

25 Um:

Each

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	iES					
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						į				
										
	:									
				,						
Part No	•	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo DQA	\ :	Date: _	
	R	esolution:	Disposition	າ:	_ QA: N	I/C Clo	sed:		Date: _	
NCR:		•	WORK ORDE	R NON-CONFORM	ANCE ((NCR)				
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
	!									
						· · ·				
						·				

							1		[

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:39 PM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 45316 Part Number: D26483 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. \$ 09/03/05 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary 8.0 QC10 VISUAL INSPECTION OF GROUND WELDS INSPECTION OF GROUND WELDS Comment: VISUAL INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 10.0 POWDER COATING POWDER COATING M109 648 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # 12.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stop Location:

Dart Aerospace Ltd	Dart	Aer	osi	oace	Ltd
--------------------	------	-----	-----	------	-----

W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			<u> </u>						
				<i>y</i> =					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposition	າ:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAN	NCE (NCR	1)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date:

Wednesday, 28/01/2009 4:59:39 PM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 45316

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/03/11 H

Dart Aerospace Lt	d	
-------------------	---	--

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Category:	NCR: Ye	s No D Q	A:	Date: _	
	Resolution:		Disposition:	QA: N/C	Closed:		Date: _	
NCD.		ton t	WORK ORDER NON-COM	JEORMANCE (NO	:R)			

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
BATE 0		Description of NC		Corrective Action Section B	Verification	A	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
			*					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H5316
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

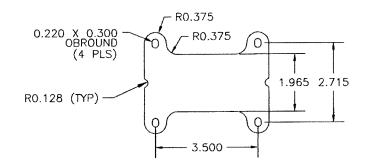
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension 1.965 2.715 3.500	Tolerance +/-0.010 +/-0.010 +/-0.010	First Article Actual Dimension 1.964 2.717	Accept	Prototy Reject	Method of Inspection	Comi	nents
1.965 2.715	+/-0.010 +/-0.010 +/-0.010	Dimension 1.964 2.717	×	Reject		Comi	nents
2.715	+/-0.010 +/-0.010	2,717					
	+/-0.010	2,717		1			-
2.500			75				
3.500		3,446	≻ c				
0.220 x 0.300	+/-0.010 x +/-0.010	· ·	Æ.				
R0.375	+/-0.010		X				
R0.128	+/-0.010	361	}				
Measured by:	<i>B</i>	Audited by:	9		Prototype App	proval:	N/A
Date:	9-3-4	Date:	01/03/0	4		Date:	N/A

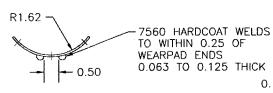
Measured by: 🚜	Audited by:	2 , ,	Prototype Approval:	N/A
Date: 9-3-4	Date:	0403/04	Date:	N/A

ı	Rev	Date	Change	Revised by	Approv <i>e</i> d
ı	Α	06.10.16	New Issue	KJ/JLM A	

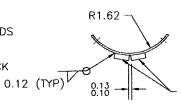
D2648-1 FLAT PATTERN



SECTION A-A

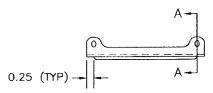


SECTION B-B

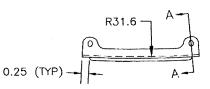


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

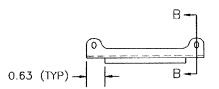




D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

ARE SHOP COPY

RETURN TO

ENGINEERING
ENGINEERING
WITHOUT NOTICE
WITHOUT NOTICE
WITHOUT NOTICE
WITHOUT NOTICE

D	99.11.17	ADDED D2648-7
С	97.06.26	R31.6 WAS R19.6
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α	97.03.25	NEW ISSUE
DESIG	DRAWN BY	DART DART AEROSPACE USA, INC.
CHEC	ED APPROVED	DRAWING NO. REV. D
1 1	忧 世	D2648 SHEET 1 OF 1
DATE	······································	TITLE SCALE
99.1	1.17	WEARPAD 1:2

Copyright 1998 by DART AEROSPACE USA, INC.